

## Procedure 2102: Installation of Pre-Formed Band Clamps Using Punch Style Tool and Air King™ Hose Shank Couplings

effective 06/16

### Selection

- Select the proper pre-formed band clamp using Procedure 1001: Pre-formed Band Clamp Selection (page 6).

### Preparation

- 1. Prepare and mark the hose using Procedure 1100: General Preparation Instructions (pages 9-10).
- 2. Refer to Procedure 2101: Installation of Pre-formed Band Clamps Using Punch Style Tool (page 21).

### Notes

- 1. For hoses having a helical wire, make certain that the clamp tail and the helical wire are pointing in the same direction. Refer to Procedure 1100: General Preparation Instructions (page 10) for illustration.
- 2. Never grasp the knob of a punch style tool with a closed fist. 
- 3. Testing is the only way to know for sure that proper tension has been achieved.
- 4. When the knobbed lever will not go to the full down position, move the pulling-dog lever to release the knobbed lever.
- 5. Use a hammer or mallet with a malleable iron or brass head.
- 6. When multiple clamps are used, clamp buckles must be offset to prevent a leak path.

### Process

- 1. Slide the clamp(s) over the hose end.
- 2. Insert the coupling. Refer to step 9 of Procedure 1100: General Preparation Instructions (pages 9-10).
  - a. *For single clamp installations on 3/8" and 1/2" couplings:*
    - 1) Position the clamp midway between the mark on the hose and the hose end.
    - 2) Tension the clamp.
  - b. *For double clamp installations on 3/4" and 1" couplings:*
    - 1) Position the first clamp just inside (hose end side) the mark on the hose.
    - 2) Tension the clamp.
    - 3) Position the second clamp midway between the clamp just installed and the hose end.
    - 4) Tension the clamp.
  - c. *For double clamp installation on 5/8" coupling:*
    - 1) Position the first clamp just inside the (hose end side) mark furthest away from the hose end.
    - 2) Tension the clamp.
    - 3) Position the second clamp just inside the (hose end side) mark closest to the hose end.
    - 4) Tension the clamp.
- 3. Inspect results using Procedure 3002: Band Clamp Inspection (page 52).
- 4. Test the assembly using Procedure 4000: General Hydrostatic Testing Information (page 60) and Procedure 4001: Hydrostatic Testing (page 61).